Date:

Thursday, 6/7/2007 3:34:20 PM

User:

Kim Johnston

**Process Sheet** 

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 32872

Estimate Number

: 10729

P.O. Number

This Issue

Prsht Rev.

:HL

: 6/7/2007

S.O. No. : HA

Type

First Issue : 32278B Previous Run

: SMALL /MED FAB

**Drawing Number** Project Number

> **Drawing Revision** Material

**Drawing Name** 

Part Number

Due Date

: D23245

: STRAP

- D2324 REV C

: N/A

: 6/26/2007

Qty:

50 Um:

Each

Written By

Checked & Approved By

Comment

: Est. E 03.02.28

Reformat; Incorporated D2324-3 & D2324-5 K

J/RF

**Additional Product** 

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M304S16GA

304/316 .063 Sheet

0.9200 sf(s) 1.0120 0.0184 sf(s)/Unit Total:

M 07 06 10

2.0

Comment: Qty.:

304/316 .063 Sheet

Comment: FLOW WATER JET

1-Cut as per Dwg D2324

Dwg Rev: C Prog Rev: C

2-Deburr if necessary

3.0

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2324-5T1

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SMALL FAB

SMALL & MEDIUM FAB RESOURCE 1



SAD A106/10 25



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

nted

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES									
DATE	STEP		PRO	OCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				· -		(%)					
		0								i i	
										1	
										-1	
Part No	):	PAF	R #:	Fault Category:		NCI	R: Yes	No DQ	A: <u></u>	Date: _	0106/24
							QA: I	N/C Close	d:		<del></del>

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC	Corrective Action Section B			Varification	Annroyal	Ι			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector			
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NOTE: Date & initial all entries

Date: User:

Thursday, 6/7/2007 3:34:20 PM

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRAP

Part Number: D23245

Description:

Job Number: 32872

Job Number:

Seq. #:

**Machine Or Operation:** 

6.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

7.0

Comment: FINAL INSPECTION/W/O RELEASE



Job Completion



U 8706-26

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES									
DATE	STEP		Р	ROCEDURE CHA	NGE	4	В	y Da	ate Qt	Approval Chief Eng / Prod Mgr	Approval QC inspector
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Part No	:		PAR #:	Fault Cate	egory:	· •	NCR: \	es No	DQA:	Date:	
							Q	A: N/C (	closed:	Date:	

	WORK ORDER NON-CONFORMANCE (NCR)									
	Description of NC		Corrective Action Section B		Varification	Approval Chief Eng	Annroyal			
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Approval QC Inspector			
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	STEP	STEP Description of NC Section A	STEP Description of NC Section A Initial Chief Eng	STEP  Description of NC Section A  Initial Chief Eng Corrective Action Section B  Chief Eng Chief Eng	STEP  Description of NC Section A  Initial Chief Eng Corrective Action Section B  Initial Chief Eng Chief	STEP Description of NC Section A Chief Eng Corrective Action Section B Sign & Date Verification Section C	STEP Description of NC Section A Description Section B Sign & Date Description Chief Eng Chief E			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32872
Description: Strut	Part Number:	D2324-5
Inspection Dwg: D2324 Rev: C		Page 1 of 1

- 2	FIRST	ARTICLE IN	SPECTION	ON CHE	CKLIST		
	х	First Artic	ele	Prote	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments
R0.38	+/-0.030	10.38			R-6		4
Ø0.257	+0.006/-0.001	0.260	V		VWN		
Ø0.191	+0.005/-0.001	0.194	1		VWV		
0.750	+/-0.010	0.754	J		ver N.		
0.375	+/-0.010	0.373			NWN		
1.875	+/-0.010	1.875	$\checkmark$		Venn		
3.000	+/-0.010	2.997			VerN		*
3.375	+/-0.010	3.370	1		VerN		
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Measured by: M. M. Audited by: Prototype Approval: N/A							
Date: (	07 06 10	Date:	0706-12			Date:	N/A

Rev	Date	Change	Revised by	Approyed
Α	06.06.05	New Issue	KJ/JLM ox	
			7 (1)	



	DESIGN B WILLIAMS	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
	CHECKED	APPROVED	DRAWING NO. REV. C D2324
	DATE 04.12.14	· ·	TITLE SCALE STRUT
	A	94.11.08	NEW ISSUE
	В	96.05.07	UPDATE MATERIALS
Γ	С	04.12.14	UPDATE NOTES

02324-5

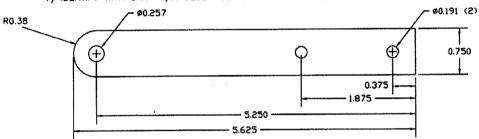
RELEASED

6.000(REF) 0 0

AN3-12A BOLT (1) AN960JD10 WASHER (2) MS21042L3 NUT (1) D2324-3 (TWO PLACES)

D2324 STRUT ASSEMBLY

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



D2324-3

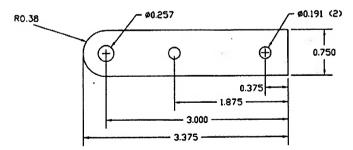
1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75

(REF DART SPEC. M6061T680.750X00.750) ACID ETCH AND ALODINE PER DART QSI 005 4.1 2) FINISH:

POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) BREAK ALL SHAPP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2324-5

AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK) 1) MATERIAL: (REF DART SPEC. M304S16GA)

POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3 2) FINISH:

3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY RETURN TO **ENGINEERING** 

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